

Date: Friday, 22/08/2008 2:02:44 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 41604	
Estimate Number : 12423	
P.O. Number :	Part Number : D35051
This Issue : 22/08/2008 S.O. No. :	Drawing Number : D3505 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : A
Previous Run : 28962	Material :
Written By :	Due Date : 02/09/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JUL 08 8.22</u>	
Comment : Est Rev:A New Issue 06-05-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2963125	105 I Beam Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

105 I Beam Extrusion 125" Long

Batch: B-28673

AWM 8-9-9



2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

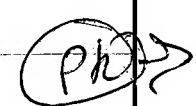
1-Cut to Length as per Dwg D3505

2-Drill Pilot Holes using DT8869 Drill Jig

3-Open pilots to 1.000" as per Dwg D3505

4-Deburr

AWM 8-9-9



Tools: Pilot

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 8-9-11

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/10	20	two webs webs were cut about 0.800" too short. R.C. Employee thought	PH QSE 042 08.09.10	possible structural implications Recommend scrap Qty @ Replac B# 24673	AWM 8-9-10	68/09/10	PH QSE 042 08.09.10	08/09/10
		measurement was 104.090" but it really is 104.900" employee read Dwg. incorrectly						

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 2:02:45 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 41604

Part Number: D35051

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 8-9-11

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part # and Batch then Stock in Landing Gear

Location: skid tube cell

LT 08-09-15

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

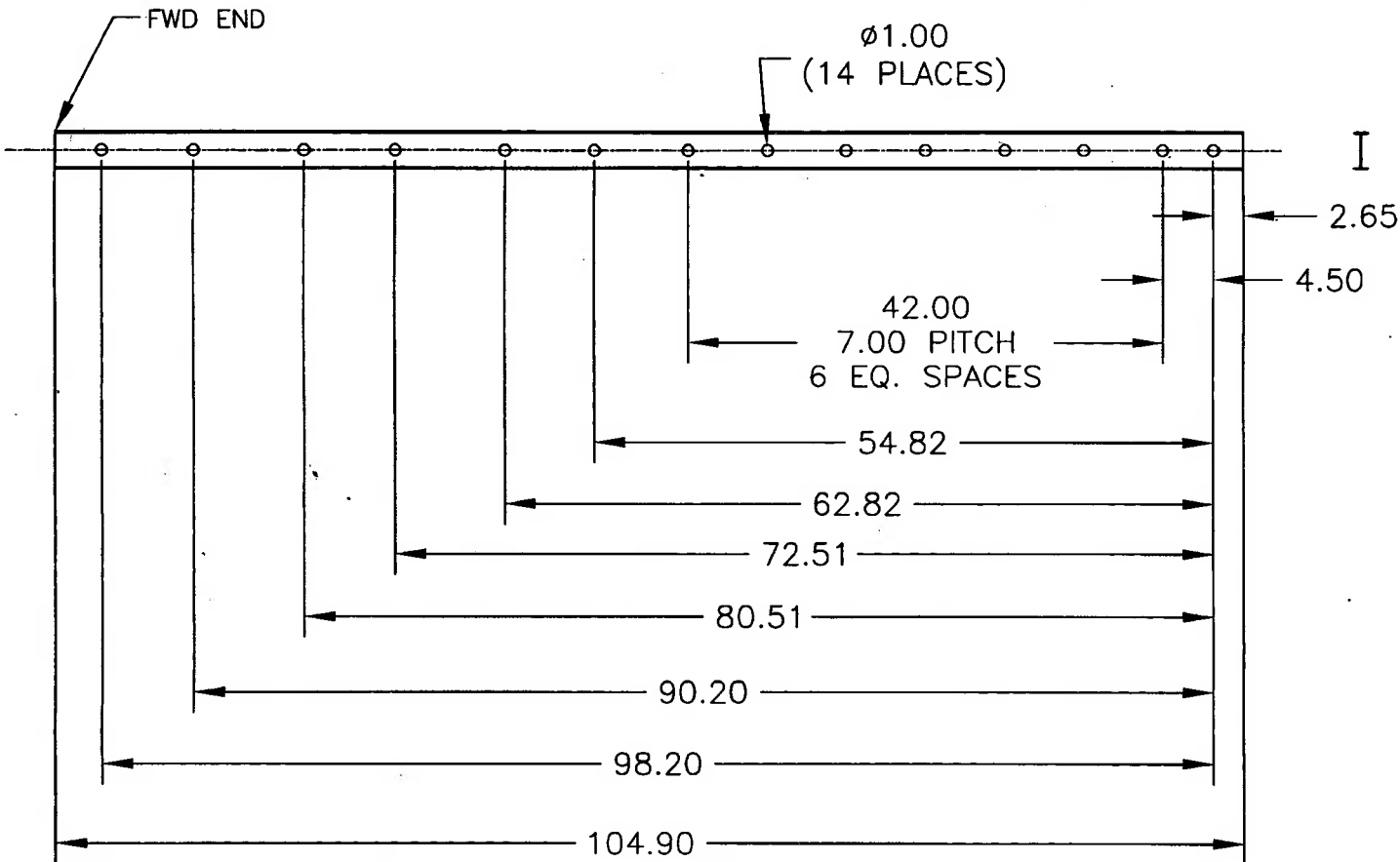
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3505	SHEET 1 OF 1
06.04.21		TITLE	SCALE
		WEB	1:15
A	06.04.21	NEW ISSUE	



D3505-1 WEB

D3505-1 WEB

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) DEBURR SHARP EDGES 0.010 TO 0.020

RE SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
06-10-02 #4
per ECU #851

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